

B are bored and slotted to receive the rods *C*. These rods are operated by the wedge cuts in push-rod *A*. The four pieces of work are ejected by pushing in rod *A*.

In work on Lincoln-type millers or on straddle-mill work, the return table movement must be long in order to eliminate the danger of the operator striking the cutters when unclamping or withdrawing the rear clamp. The necessity of the extra

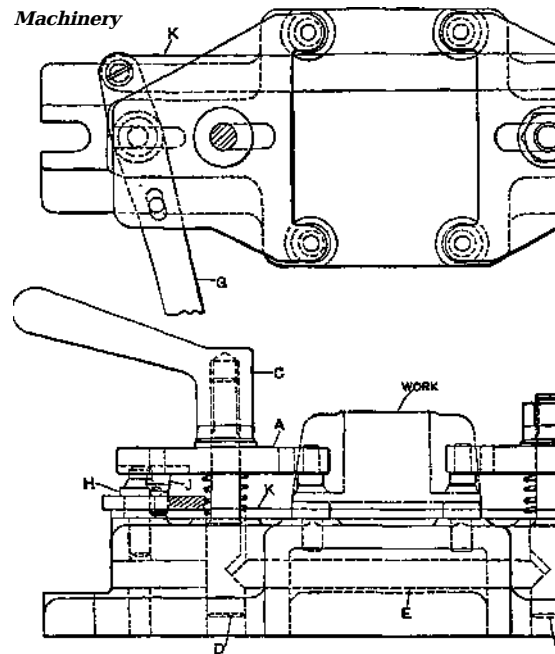


Fig. 26. Fixture Designed for use on Lincoln Milling- Machine

long table return is done away with in the straddle-milling fixtures illustrated in Fig. 26. The clamps are operated entirely from the front of the fixture, thus making it unnecessary for the operator to reach in near the cutters. Clamps *A* and *B* are operated by the handle *C* through stud *Z*, rod *f*, and stud *F*. The clamps are withdrawn by lever *G*, which is

pivoted on stud *H* and operates clamp *A* by means of pin 7. The strap *K* is connected to the other end of lever *G* and operates the rear clamp by pin *L*.